

Work Order ID 53929

November 23, 2009 2:52:14 PM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Armrest Assembly

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 07/11/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3780

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780

****torque screws as per dwg D3780****

10/02/16 (2)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/21/16

(2)

120

0.00



Identify as per dwg & Stock Location:

Packaging

Memo

0.00

Packaging

10-2-17 SL (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53929

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Page 2

Item ID: D3780-041
Revision ID: D
Item Name: Armrest Assembly

Accept



Setup Start



Stop



Start Date: 23/11/2009 Start Qty: 2:00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18 J

MF

10-2-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:52:21 PM

Page 1

Work Order ID: 53929

Parent Item: D3780-041RevD

Parent Item Name: Armrest Assembly

Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3696-041RevC Manufactured No



B46201 (2X)

~~B3696-041~~



EP 10/02/16

Arm Assembly

D3781-041RevC Manufactured No



100

Each

1.0000

2.0000



EP 10/02/16

Lateral Cushion Assembly

Warehouse

Loc Qty

Loc Code

Location

B55173 (2X)

Main Warehouse

ST

1

47992

1

D3781-043RevD Manufactured No



100

Each

0.0000

2.0000

B55173 (2X)



EP 10/02/16

Armrest Cushion Assembly

D3785-3RevC Manufactured No



100

Each

6.0000

2.0000



EP 10/02/16

Bracket

Warehouse

Loc Qty

Loc Code

Location

B54826 (2X)

Main Warehouse

ST130

6

51700

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:52:21 PM

Work Order ID: 53929

Parent Item: D3780-041RevD

Parent Item Name: Armrest Assembly




Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3977-1RevA  Bolt		Manufactured	No			100	Each	1.0000	2.0000		<u>9/5/10/02/16</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>51701</div> <div>Loc Qty</div> <div>1</div> <div>Loc Code</div> <div>B 55180 (IX)</div>												
D3978-1RevA  Nut		Manufactured	No			100	Each	1.0000	2.0000		<u>9/5/10/02/16</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST139</div> <div>51702</div> <div>Loc Qty</div> <div>1</div> <div>Loc Code</div> <div>B 55182 (IX)</div>												
D3979-1RevA  Washer		Manufactured	No			100	Each	6.0000	2.0000		<u>9/5/10/02/16</u>	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>51703</div> <div>Loc Qty</div> <div>6</div> <div>Loc Code</div> <div>B 55182 (IX)</div>												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:52:21 PM

Work Order ID: 53929



Parent Item: D3780-041RevD



Parent Item Name: Armrest Assembly

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L 		Purchased	No			100	Each	5,592.000	4.0000			
Washer												

ES 10/02/16

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5592	
101291	16	
104885	153	
105793	236	
109632	348	
110985	4839	

4

AN970-6

Purchased

No

100

Each

44.0000

4.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	44	
10538	8	
109798	36	

4

ES 10/02/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 53929



Parent Item: D3780-041RevD



Parent Item Name: Armrest Assembly

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 Nut		Purchased	No			100	Each	2,938.000	4.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2938

110844

32

111274

27

111668

387

112314

1992

112385

500

ES 10/02/16

MS24665-302



Cotter Pin

Purchased

No

100

Each

25.0000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

111359

25

ES 10/02/16

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

November 23, 2009 2:52:21 PM

Work Order ID: 53929

Parent Item: D3780-041RevD

Parent Item Name: Armrest Assembly


Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-C272		Purchased	No			100	Each	1,436.000	4.0000			
												
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1436	
17137	519	
17831	520	
8814	3	
8815	34	
9063	60	
9370	300	

ES 10/02/16

MS24693-C277

Purchased

No



Screw

100

Each

16.0000

4.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	16	
109297	16	

ES 10/02/16

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 6

November 23, 2009 2:52:21 PM

Work Order ID: 53929



Parent Item: D3780-041RevD



Parent Item Name: Armrest Assembly

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1149D0663J

Purchased

No

100

Each

195.0000

2.0000



Washer

ES 10/02/16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

195

112612

195

2

November 23, 2009 2:52:21 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

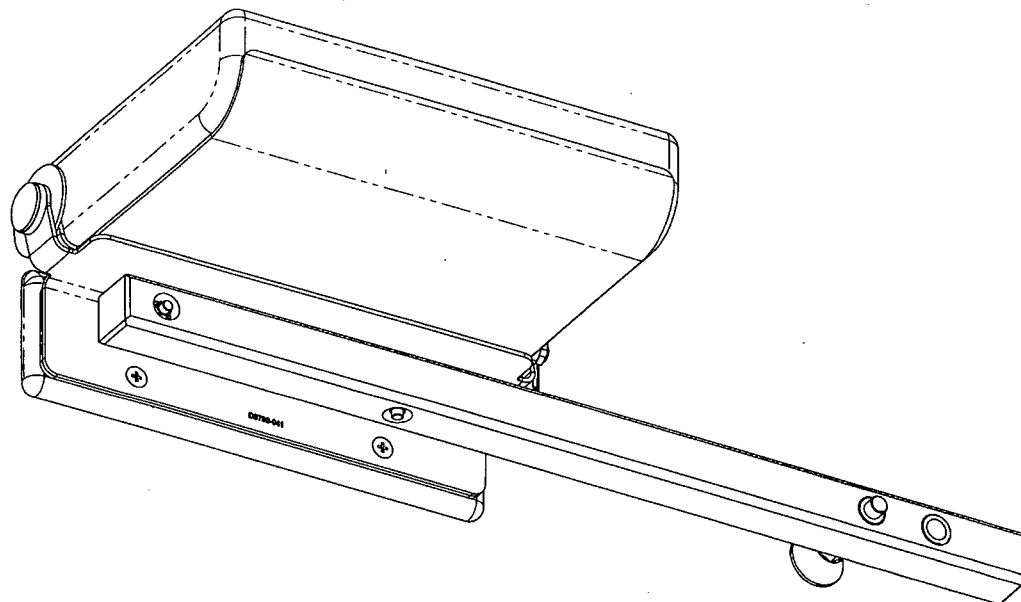
5

4

3

2

1

**D3780-041 ARMREST ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

STANDARD
RETURN
ENCLOSURE
UNCONTROLLED COPY
SUBJECT TO AVALANCHE
WITHOUT NOTICE
WORK ORDER
NO. 53929
BS 09-11-23

RELEASED
08/07/21/14/20

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3780 REV. D SHEET 1 OF 3 TITLE ARMREST ASSEMBLY SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

8

7

6

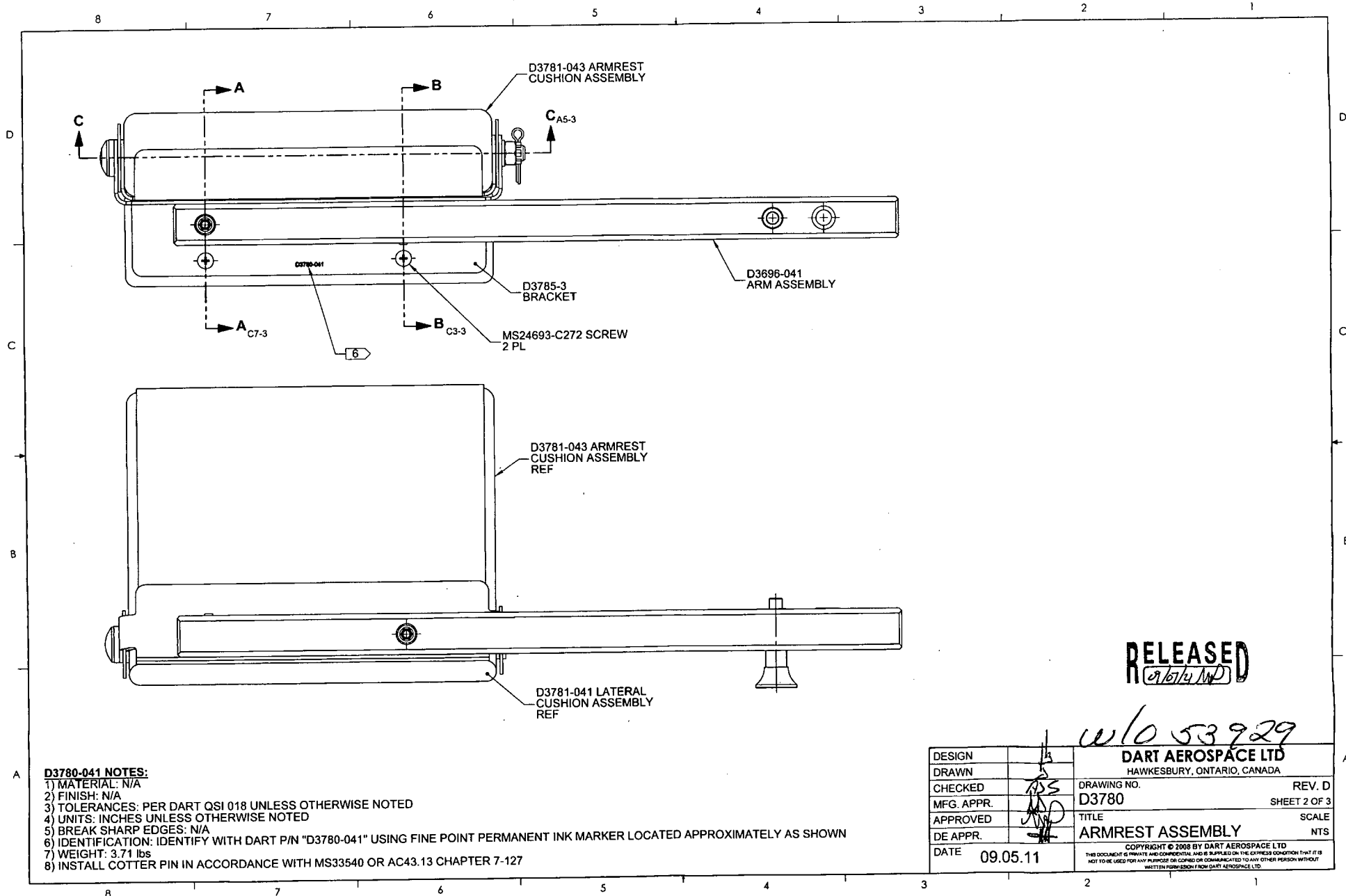
5

4

3

2

1



RELEASED
2/6/14 MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS24693-C277
SCREW

MS21042L3
NUT
AN960JD10L
WASHER
MS24693-C272
SCREW

SECTION A-A C7-2

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3785-3
BRACKET
REF
AN960JD10L
WASHER
MS21042L3
NUT
MS24693-C272
SCREW

SECTION B-B C6-2

AN970-6 WASHER
2 PL

NAS1149D0663J
WASHER

D3978-1 NUT (CASTELLATED), UNC
MS24665-302 COTTER PIN (8)

D3785-3 BRACKET
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

D3979-1 WASHER (SQUARE HOLE)

SECTION C-C D5-2
SCALE: 2X

RELEASED
07/07/14

w/0 53929

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	09.05.11

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3780	REV. D
TITLE ARMREST ASSEMBLY	SHEET 3 OF 3
DATE	SCALE NTS
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